

82975

Thursday, April 12, 2012 10:00:22 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 4/12/2012 **Start Qty:** 10.00

10

Required Date: 4/20/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:**

Date: 12 Oct 12 Tooling:

Date:

QC:

Date: _____ **SPC (Y/N):** _____

Date:

NR2

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4021 | B |

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg. D4021

Prog Rev:

Dwg Rev:

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

82975

Thursday, April 12, 2012 10:00:22 AM

N900040100

Setup Start ***NS1***

Stop ***NS2***

10

10

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

120

0.00

0.00 Sizheke

10

0.00

130

0.00

1- make radius as per dwg
2- deburr

0.00

140

0.00

0.00
0.00

Σ 1714112

410

DL/12-4-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 82975***82975***

Page 3

Thursday, April 12, 2012 10:00:22 AM

Item ID: D4021-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Hoop
Start Date: 4/12/2012 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/20/2012 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

10x 12-04-19

12/4/19

12-04-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 12, 2012 10:00:27 AM

Page 1

Work Order ID: 82975

82975

Parent Item: D4021-7

D4021-7

Parent Item Name: Hoop

Start Date: 4/12/2012

Required Date: 4/20/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB
DD 10.04.20 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304B0.625X3.000 | | Purchased | | | | 100 | f | 10.6160 | 0.4166 | 4.385263 | | | |

M304B0 625X3 000

**

304 BAR .625 X 3.00

Location

Loc Qty

Loc Code

MAT050

10.616

117130

0.55

118900

0.166

121216

9.9

121216 -
118917 -

ml/Jm
12-4-15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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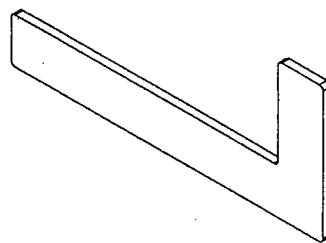
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

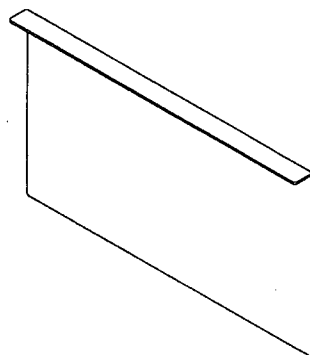
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

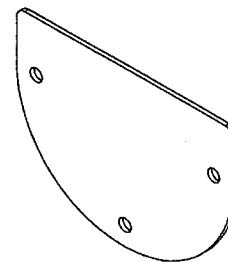
8 7 6 5 4 3 2 1



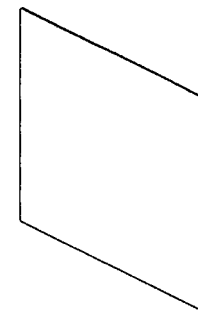
D4021-1 HANDLE PLATE



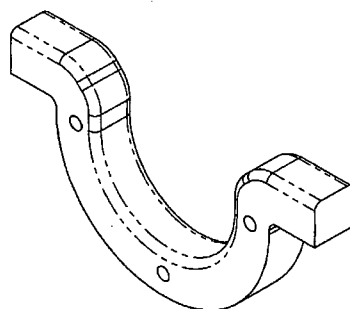
D4021-3 DATA PLATE



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



D4021-9 BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82925

12-09-12

RELEASED
2010-04-14

| B | POWDER COAT SPEC ADDED TO NOTE 2 (A8-2) | JPH | 10.04.06 |
|------------|---|---|----------|
| A | NEW ISSUE | JPH | 10.01.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4021 SHEET 1 OF 3 TITLE MISC PARTS - 350 BASKET SCALE NTS | |
| DRAWN | JPH | | |
| CHECKED | <i>[Signature]</i> | | |
| MFG. APPR. | <i>[Signature]</i> | | |
| APPROVED | <i>[Signature]</i> | | |
| DE APPR. | <i>[Signature]</i> | | |
| DATE | 10.04.06 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

8 7 6 5 4 3 2 1

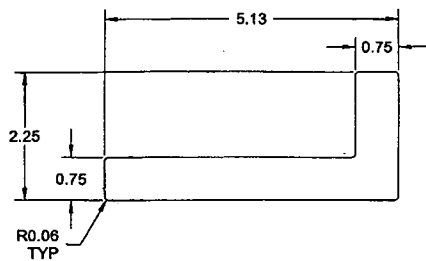
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

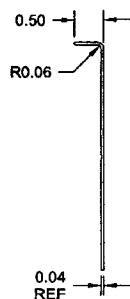
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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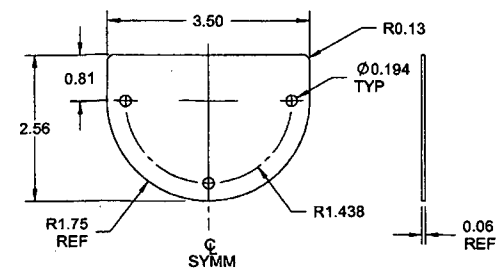
NOTE: Date & initial all entries



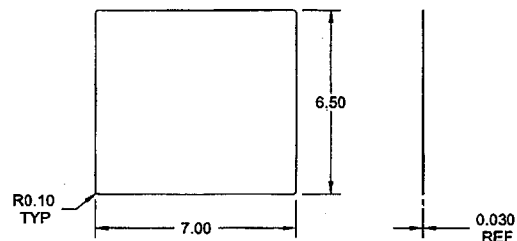
D4021-1 HANDLE PLATE



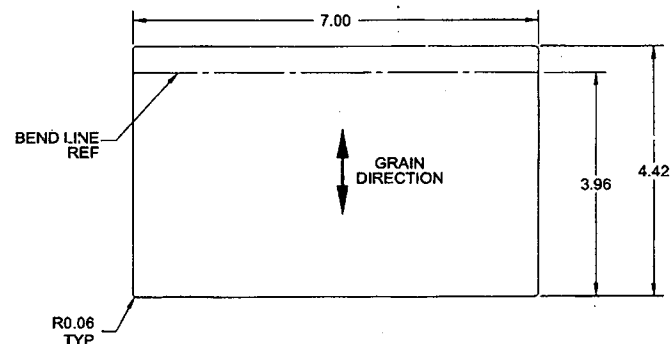
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-3F DATA PLATE
FLAT PATTERN




RELEASED
R 2010-04-14
NMP

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH : -1/-3/-11: NONE
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs -3: 0.35 lbs
-5: 0.14 lbs -11: 0.39 lbs

82975

| | | | |
|--|---|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JPH | DRAWING NO. | REV. B |
| MFG. APPR. |  | D4021 | SHEET 2 OF 3 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | MISC PARTS - 350 BASKET | NTS |
| DATE | 10.04.06 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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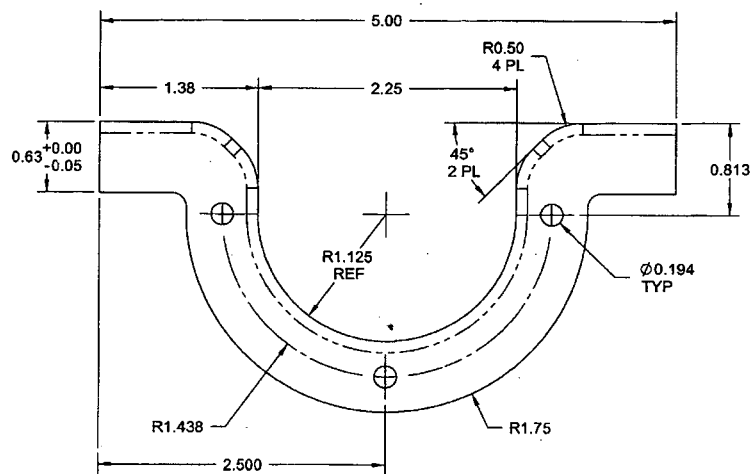
| W/O: | | WORK ORDER CHANGES | | | | | |
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| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

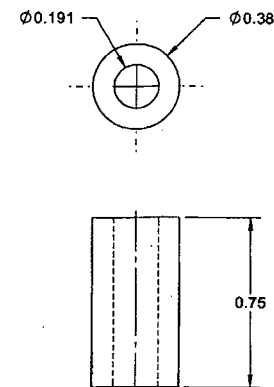
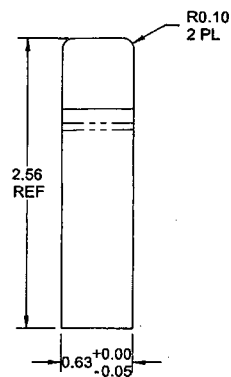
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries



D4021-7 HOOP



D4021-9 BUSHING

NOTES:

1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT -7: 0.80 lbs

-9: 0.02 lbs

82929

RELEASED
2010-04-14
NR

| | | | |
|--|--------------------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D4021 | SHEET 3 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | MISC PARTS - 350 BASKET | NTS |
| DATE | 10.04.06 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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NOTE: Date & initial all entries

